Work Order 1 February 7, 2011 7											Page 1		
Revision ID:	275-1 ssbolt Spacer		Accept					-	Start Stop				
	7/11 Start Qty: 40.0			Cust Item I Customer:	D:					1 1 39 111 11 1	1818 118 1181 1881		
	rocess Plan: CX	Date: <u> /02/0</u>) Date:	Tooling: SPC (Y/N):		ate:				Start Stop				
Sequence ID/ Work Center ID	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp		
Draw Nbr D3275	Revision Nbr Rev A1									·			
Hardinge CNC Lathe Sm	Hardinge CNC LATI	s per Folio FA469 and Dwg D3:	0.00 0.00 275 1)2124				40	Ţ					
110 QC Quality Control	QC2- Inspect parts o	ff machine FAI/FAIB	0.00				40) . <u> </u>					

120

QC8- Inspect parts - second check

0.00

5) 1112124

M. 2.24 40 0

Quality Control

Memo

0.00

Dart Ae	rospace	e Ltd							
W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	s No DQ	A:	Date: _	
	R	esolution:	Disposition: QA: N/C Closed: Date:						
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	0.750	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	ا& ∣ _{Sec}	tion C	Chief Eng	QC Inspector
	 								

Work Order ID 66109

February 7, 2011 7:32:25 AM



Page 2

Item ID:

D3275-1

Accept



Setup Start



Revision ID:

Item Name:

Required Date: 2/11/11

Crossbolt Spacer

Start Date:

2/07/11

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: QC:

Date: Date:____

Tooling: SPC (Y/N):

Date: Date:

Tool # Plan

Code

Start

Run

Stop

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

STOCK IN SKIDTUBE CELL

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Qty

Reject Qty

Reject Insp. Number Stamp

Accept

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11-02-25

Dart Aerospace Ltd

Duit Aci	ССРИСС		., .									
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE	B	y [Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					,	_						
Part No	<u>.</u>	PAR #:	Fault Cat	egory:	NCR: \	∕es No	DQ/	\ :	Date:			
			Disposition:									
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC	Corrective Action Section			ign &	Verification		Approval	Approval		
DAIL	JIL!	Section A	Initial Chief Eng	Action Description Chief Eng	1	Date	Secti	on C	Chief Eng	QC Inspector		
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	1									•		
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	,							,				

Picklist Print

February 7, 2011 7:32:25 AM

Work Order ID: 66109

Parent Item:

D3275-1

Parent Item Name: Crossbolt Spacer



Start Date: 2/07/11

Required Date: 2/11/11

Start Oty: 40.00

Required Qty: 40.00

Ja W2/24

Comments:

IPP Rev:A□04.10.19□New issue□KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primar Item Locatio	,	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05		Purchased	No		100	f	18.0840	0.2666	11.22526	· •		



ALUM TUBE .3125 x .058w

Location Loc Code Loc Oty MAT 18.084 116793 18.084

116939

Dart Aerospace Ltd

	<u> </u>										
W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
, ,,,,			-			<u> </u>					
Part No	• •	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _			
	R	esolution:	Dispositi	on:	_ QA: N/C CI	Date:					
NCR:		1	WORK ORDER NON-CONFORMANCE (NCR)								
D.4.7.5	0755	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector		
í											

DART AEROSPACE LTD	Work Order:	66109
Description: Crossbolt Spacer	Part Number:	D3275-1
Inspection Dwg: D3275 Rev: A1		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST X First Article Prototype											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comm	ents					
3.180	+/-0.010	3.181			Ver	5/-	٦					
0.025 - 0.030	N/A	-025			/	- 1						
45°	+/-0.01°	450										
Ø0.313	+0.010/-0.005	0.309										
0.058	Max = 0.0605 Min = 0.0555	-058										
							•					
			-									
							,					
				,								
·												
Measured by:		Audited by:	in		Prototype /	Approval:	N/A					
Date:	11/2/24	Date:	11.2	- 24		Date:	N/A					

Measured by:	12	Audited by:	Prototype Approval:	N/A
Date:	11/2/24	Date: 11. 2 - 24	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.10.19	New Issue	KJ/JLM	
В	06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM , A	
С	09.05.04	Ø0.197 dimension removed	KJ/DD	<i>M</i>
			- 1//	74 7

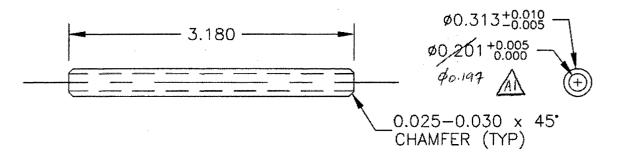




	DESIGN	W	DRAWN BY	DART AEROSPACE US	A, INC.
	CHECKED	νA	APPROVED A	DRAWING NO.	REV. A
		#	I H	D3275	SHEET 1 OF 1
	DATE			TITLE	SCALE
·	04.03.	10		CROSS BOLT SPACER	1:1
	Α	ıJ	04.03.10	NEW ISSUE	
	AI G	ar	04.10.19	CHANGE MAT'L SPEC	

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 66109

CZ11/02107



D3275-1 CROSS BOLT SPACER

1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6T0:313W.058 AD

2) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			 		·				Prod Mgr			
		,										
Part No	:	PAR #:	Fault Cat	egory:	NCR	: Yes 1	lo DQ	A:	_ Date: _			
	R	esolution:	Disposition:				sed:		Date: _			
NCR:		V	VORK ORI	DER NON-CONFORM	MANCE	(NCR)						
DATE	OTED	Description of NC Corrective Action			ection B		Verific	ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Secti		Chief Eng	QC Inspector		
				-				_				
				•								
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